

Amendments to the Specification:

Amend the paragraph commencing at page 1, line 14 and ending at page 2, line 2, as follows:

As shown in Fig. 12, a gun drill system includes a gun drill 30 consisting of a tubular tool shank 31 and a drill head 32. The tool shank 31 has an outer axial discharge groove 34 V-shaped in radial section. The drill head 32 is fixed to the front end of the tool shank 31. The interior of the tubular shank 31 serves as a supply passage 33. While the gun drill 30 is cutting a deep hole H in a work W, it produces shavings ~~T S~~ in the hole H. In the meantime, a high pressure coolant C is supplied through the supply passage 33 and discharged from the front end of the drill head 32 so as to expel the shavings ~~T S~~ through the discharge groove 34. Even if the gun drill 30 is small in diameter, the discharge groove 34 can be large in radial section so that the shavings ~~T S~~ are relatively easy to discharge.